

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-004515**Date Inspected:** 29-Oct-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 1400**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 2200**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shangxing Island, Shanghai**CWI Name:** Chen Xi**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Deck panel**Summary of Items Observed:**

On this date CALTRANS OSM Quality Assurance (QA) representative was present for observations relative to fabrication performed by Zhenhua Port Machinery Company (ZPMC) for the fabrication of Orthotropic Box Girder (OBG) and SAS Tower at Changxing Island, in Shanghai, China.. While on site the QA Inspector noted the following:

Deck Panel # DP001-001

1. The QA Inspector performed Ultrasonic Testing (UT) verification on partial joint penetration welds made between the U-ribs and the flat plate of the assembly identified as deck panel DP001-001. The QA Inspector performed the UT verification on the weld number two and three in conjunction with the QA Inspector Kenneth Riley. The QA Inspector performed the UT verification at random locations on the mentioned welds to verify the weld's depth of penetration inspected and accepted by the ZPMC Quality Control Inspection personnel. The QA Inspector observed one indication on the weld number three that appeared not to be in compliance with the ZPMC supplementary ultrasonic testing procedure number ZPQC-UT-02. The QA Inspector marked on the steel the indication's location and data for the ZPMC Quality Control personnel to perform additional verification. The QA Inspector and Kenneth Riley notified the ZPMC Quality Control Inspection personnel of the indication observed. Please see the QA Inspector's daily welding report (TL 6031) generated by Kenneth Riley for additional information. The QA Inspector completed the verification on these welds at this location on this date. The QA Inspector notified Task Leader Albert Carreon of observations during testing.

Deck Panels

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2. The QA Inspector performed a random Magnetic Particle Testing (MT) verification on the completed partial joint penetration welds made between the U-ribs and flat plate of the identified deck panel number DP541-001 welds 001 through 006, DP380-001 welds 001 through 010, DP460-001 welds 001 through 010, DP109-001 welds 001 through 008, DP556-001 welds 001 through 010, DP566-001 welds 001 through 006, DP611-001 welds 001 through 008 and DP576-001 welds 001 through 008. The QA Inspector performed the MT verification on these welds after ZPMC Quality Control Inspection personnel had completed the visual, MT inspections and reported the welds to be acceptable and ready for the QA Inspector verification. (Please see note below). The QA Inspector performed the MT verification at random locations on the welds. The QA Inspector did not observe any relevant indications during the verifications. The QA Inspector notified Task Leader Albert Carreon of the observations during verification. Please see the QA Inspector's Magnetic Particle Testing (TL 6028) report generated on this date for additional information.

NOTE: Please note that the visual verification on these welds had been performed by other QA Inspector prior to the QA Inspector's MT verification.

Summary of Conversations:

As noted within the body of the report above.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Peter Dautermann, (1500) 129-9593, who represents the Office of Structural Materials for your project.

Inspected By:	Medina,Ricardo	Quality Assurance Inspector
Reviewed By:	Carreon,Albert	QA Reviewer
